

Work Order ID 59849

Monday, June 14, 2010 2:32:04 PM



Page 1

Item ID: D2571	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Saddle, Fwd Out 205					
Start Date: 6/14/2010	Start Qty: 12.00		Cust Item ID:		
Required Date: 7/5/2010	Req'd Qty: 12.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date: 10-6-14	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2571	Rev E								

100	HAAS CNC VERTICAL MACHINING #1	0.00	H.A	10/06/15	9	0		
	HAAS 1							

HAAS CNC vertical machine #1

Memo

Program Batch No. 59849 Double check by 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect

110	CONVENTIONAL MILLING MACHINE	0.00	H.A	10/06/15	9	0		
	Mill Conv							

Conventional Milling Machine

Memo

Machine keyway as per dwg D2571 & D2572

120	QC2- Inspect parts off machine FAI/FAIB	0.00	H.A	10/06/15	9	0		
	QC							

Quality Control

Work Order ID 59849

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Item ID: D2571

Accept



Setup Start



Revision ID:

Item Name: Saddle, Fwd Out 205

Stop



Start Date: 6/14/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 7/5/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

mk 10/06/21

9 0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

mk 10 05 21 (9)

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

M114841

START TIME:

8:40

OVEN TEMPERATURE:

350° FINISH TIME:

9:10

9 BL 10-6-22

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Page 3

Item ID: D2571

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 6/14/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 7/5/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

10-6-23 9x SP

170



Packaging

Packaging

Identify as per dwg & Stock Location: 433

0.00

Memo

0.00

10-6-23 9x SP

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/23 9x SP

V 10-06-23

Picklist Print

Monday, June 14, 2010 2:32:08 PM

Page 1

Work Order ID: 59849



Parent Item: D2571

Parent Item Name: Saddle, Fwd Out 205

Start Date: 6/14/2010

Required Date: 7/5/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: I02.10.02 Re-format; Change to Dwg Rev. D & incorporated
D2572 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007 		Manufactured	No			100	Each	39.0000	1	12			
Saddle Billet													

Location

Loc Qty

Loc Code

MAT42

39

46412

2

58677

37

2.0 K.A 10/06/15

DART AEROSPACE LTD	Work Order:	39849
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.441	0.441	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		0.501	0.502	0.505	0.505		
G	0.257	0.262		0.260	0.260	0.260	0.260		
H	0.375	0.380		0.376	0.376	0.376	0.376		
I	0.490	0.510		0.499	0.500	0.503	0.503		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.566	0.568	0.564	0.564		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.126	0.126	0.126	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.250	0.252	0.252		
S	0.115	0.135		0.128	0.128	0.124	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.959	2.959	2.960	2.960		
V	0.230	0.250		0.240	0.236	0.237	0.237		
W	0.115	0.135		0.123	0.124	0.124	0.124		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.762	0.762	0.762	0.762		
Z	0.352	0.372		0.362	0.363	0.363	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.628	0.625	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.247	0.240	0.240		
AE	1.375	1.395		1.388	1.391	1.389	1.389		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.240	0.240	0.240	0.240		
AH	0.240	0.260		0.248	0.245	0.245	0.245		
AI	2.000	2.020		2.001	2.002	2.001	2.001		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	B.A
Date:	10/06/16

Audited by:	[Signature]
Date:	10/06/16

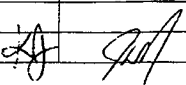
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	[Signature]

DART AEROSPACE LTD	Work Order:	59829
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	16	17	18		
A	0.438	0.443		.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.002	8.002	8.002		
F	0.490	0.510		.501	.501	.501	.501		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.499	.499	.499	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.566	.566	.566	.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.126	.126	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.128	.128	.128	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.959	2.959	2.959	2.959		
V	0.230	0.250		.240	.250	.250	.250		
W	0.115	0.135		.123	.123	.123	.123		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.762	.762	.762	.762		
Z	0.352	0.372		.362	.362	.362	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.625	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.247	.247	.247		
AE	1.375	1.395		1.388	1.388	1.388	1.388		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.240	.240	.240	.240		
AH	0.240	0.260		.248	.248	.248	.248		
AI	2.000	2.020		2.004	2.008	2.008	2.008		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: 	Audited by: 
Date: 10-6-18	Date: 10/6/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order:	598029
Description: Saddle, Fwd Outboard		Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				# 9	# 10	# 11	# 12		
A	0.438	0.443		.441					
B	1.745	1.755		1.750					
C	3.495	3.505		3.500					
D	1.745	1.755		1.750					
E	7.990	8.010		8.002					
F	0.490	0.510		.501					
G	0.257	0.262		.260					
H	0.375	0.380		.376					
I	0.490	0.510		.499					
J	1.174	1.184		1.179					
K	0.558	0.578		.566					
L	1.174	1.184		1.177					
M	1.490	1.500		1.495					
N	2.495	2.505		2.500					
O	3.869	3.879		3.874					
P	0.115	0.135		.126					
Q	0.115	0.135		.135					
R	0.240	0.260		.250					
S	0.115	0.135		.128					
T	0.178	0.198		.188					
U	2.940	2.980		2.959					
V	0.230	0.250		.240					
W	0.115	0.135		.123					
X	0.308	0.313		.310					
Y	0.760	0.765		.762					
Z	0.352	0.372		.362					
AA	0.470	0.530		.500					
AB	0.615	0.635		.625					
AC	0.053	0.073		.063					
AD	0.240	0.260		.247					
AE	1.375	1.395		1.388					
AF	0.115	0.135		.135					
AG	0.240	0.280		.240					
AH	0.240	0.260		.248					
AI	2.000	2.020		2.004					
AJ	0.023	0.043		.033					
Accept/Reject									

Measured by:	B.A
Date:	10/06/18

Audited by:	mr
Date:	10/06/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK CENTER

NO. 59849

RELEASED

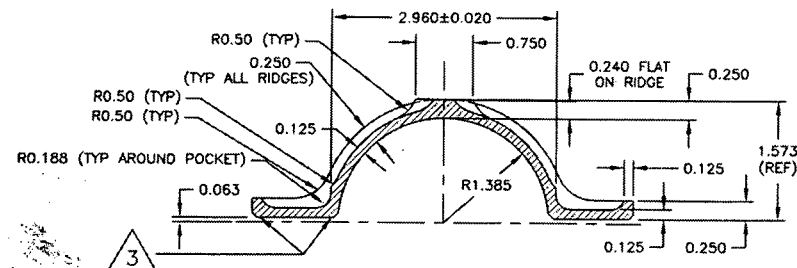
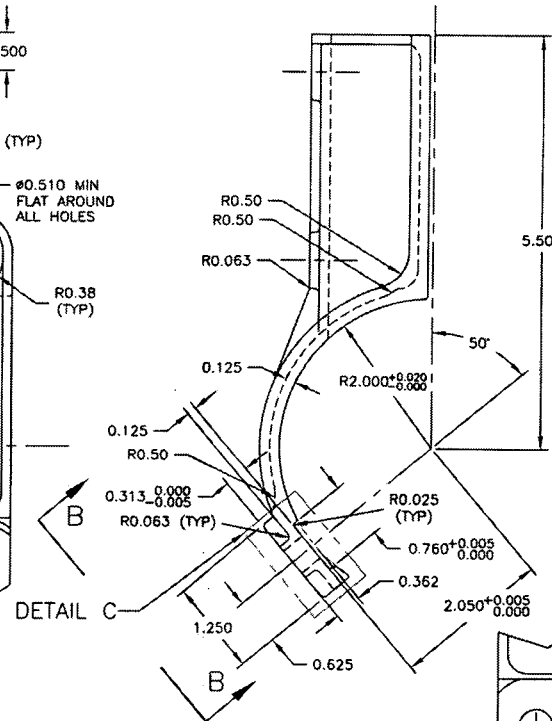
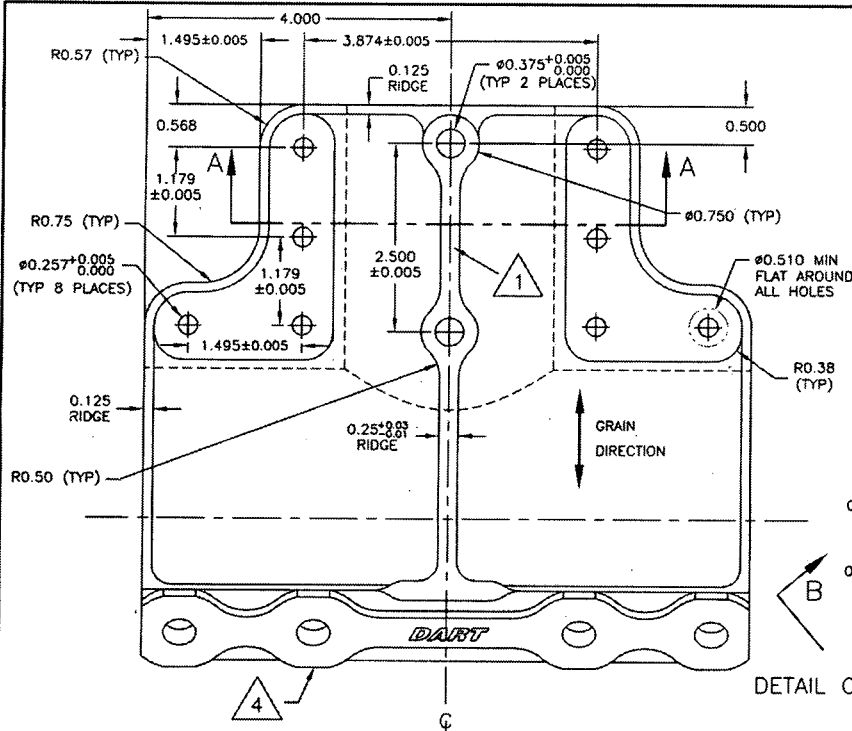
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NOTES

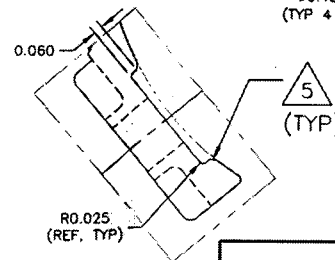
MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

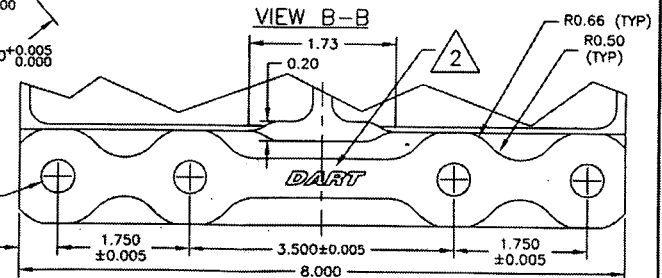
E



SECTION A-A



DETAIL C
SCALE 4:3



E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

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DESIGN DS	DRAWN BY PH	DART DART AEROSPACE LTD. WARRICKS, ONTARIO, CANADA	REV. E
CHECKED #	APPROVED #	DRAWING NO. 02571	SHEET 1 OF 1
DATE 05.07.13	TITLE OUTER FWD SADDLE	SCALE 2:3	